









Work Order ID 64309

Thursday, December 02, 2010 8:56:30 AM

Page 1


Item ID:	D2150	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Packer Doubler, Hinge					
Start Date:	12/2/2010	Start Qty:	20.00		Cust Item ID:	
Required Date:	12/9/2010	Req'd Qty:	20.00		Customer:	

Reference:

Approvals:	Process Plan:		Date:	10/12-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2150	Rev A


100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2150 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2-								
2004 040	Deburr if necessary								

10-12-7

62

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10-12-7

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8/10/12/08

cont
720

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64309

Thursday, December 02, 2010 8:56:30 AM

Page 2

Item ID: D2150

Accept

Setup Start

Revision ID:

Stop

Item Name: Packer Doubler, Hinge

Start Date: 12/2/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Debur

=> m-l 10/12/08

20X

140

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

=> M 10/12/08

20 9

150

0.00



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

Powder Coating

M115951

START TIME:

10:55

OVEN TEMPERATURE:

300 FINISH TIME:

11:25

20 10-12-B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 64309

Thursday, December 02, 2010 8:56:30 AM



Page 3

Item ID: D2150

Accept



Setup Start



Revision IP:

Stop



Item Name: Packer Doubler, Hinge

Start Date: 12/2/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00

=) JEL

10/12/13

20

9

QC Memo

0.00

Quality Control

170 Identify as per dwg & Stock Location: 007

0.00

Packaging Memo

0.00

Packaging

CK 10/12/13 (20)

180 QC21- Final Inspection - Work Order Release

0.00

QC Memo

0.00

Quality Control

CK 10/12/13

ME 10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, December 02, 2010 8:56:34 AM

Work Order ID: 64309



Parent Item: D2150



Parent Item Name: Packer Doubler, Hinge

Start Date: 12/2/2010

Required Date: 12/9/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ C100.11.27 ☐ Re-format (mpp 2101) ☐ EC ☐
IPP Rev:D 06-08-23 Now on Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040		Purchased	No			100	sf	237.3400	0.025	0.526316			
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2024-T3 .040 sheet



12-10-12-7

Location	Loc Qty	Loc Code
MAT	47.6	
114415	47.6	
MAT22	189.74	
110305	21.93	
111786	9.66	
112291	28.25	
112331	52	
113162	77.9	

114415

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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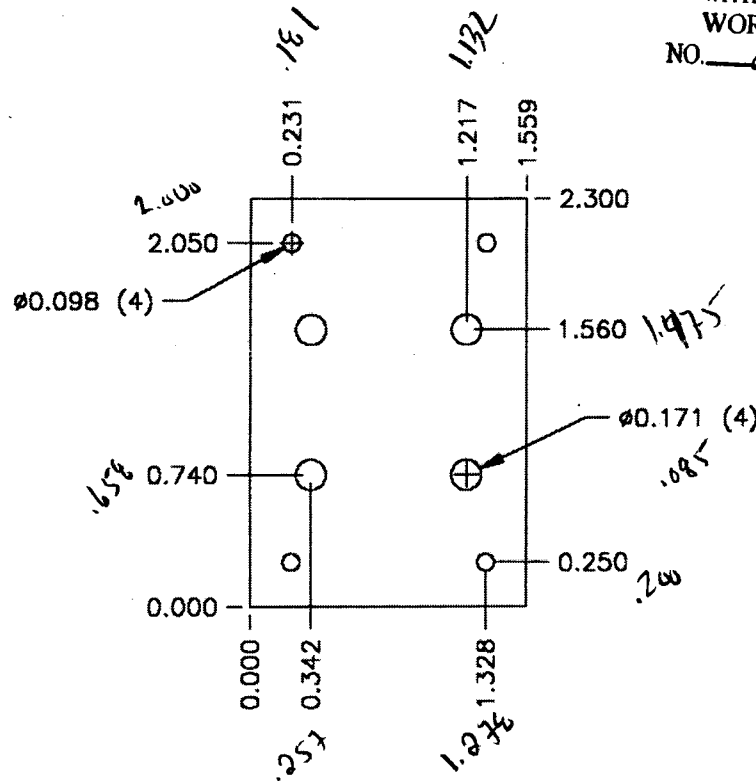
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED	APPROVED	D2150	SHEET 1 OF 1
DATE	TITLE	PACKER	SCALE
95:05:01			1:1

RELEASED
96/06/13 BWS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44309
8/10-122



MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS